

Work Order ID 86483

June-29-12 1:31:46 PM

86483

Page 1

Item ID: D212-580-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012 Start Qty: 200

P
P

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 200

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/29 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	B2								
IIN-D212-580-1	A	5.50							
100		0.00							

100

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

DAS
16
8-89

MLJ 12108117

160

Pick Kit

0.00

160

Packaging

Packaging

Memo

0.00

4x

80
12-7-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86483

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Page 2

Item ID: D212-580-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Cargo Mirror Assembly, 8 inch Round

Start Date: 29/06/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	DAS 16 8-89	7/08/12		MC			

180 *180* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D212-580-041 Location: <u>4</u> PPP Rev: _____	0.00							
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190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							
--	---	------	--	--	--	--	--	--	--

MC 12/08/12

MC 12/08/12

MC
12-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-29-12 1:31:50 PM

Work Order ID: 86483

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly, 8 inch Round

86483
D212-580-041

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 2,00

Required Qty: 2.00

Comments: IPP Rev:H Removed D2013-3-4 06-03-22 JLM
IPP REV:I AS PER ECN10-611 10-09-07 JLM VERIFIED
BY:DD 10.11.22 AS PER ECN10-642 DD VERE:JLM IPP rev:

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST316	2750	
104374	236	
110398	2514	

100 Each 60.0000  810

Location Loc Qty Loc Code
ST104 60

<u>82782</u>	20	12
83422	40	44

700

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-29-12 1:31:50 PM

Page 2

Work Order ID: 86483

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly, 8 inch Round

86483
D212-580-041

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08

Purchased

No

100

Each

1,180.000

810
**

MS27039-1-08

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST291	1180	
117423	81	
119075	1	
120308	166	
121011	43	
121243	500	
121708	389	

SP 12-7-26
m122452

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

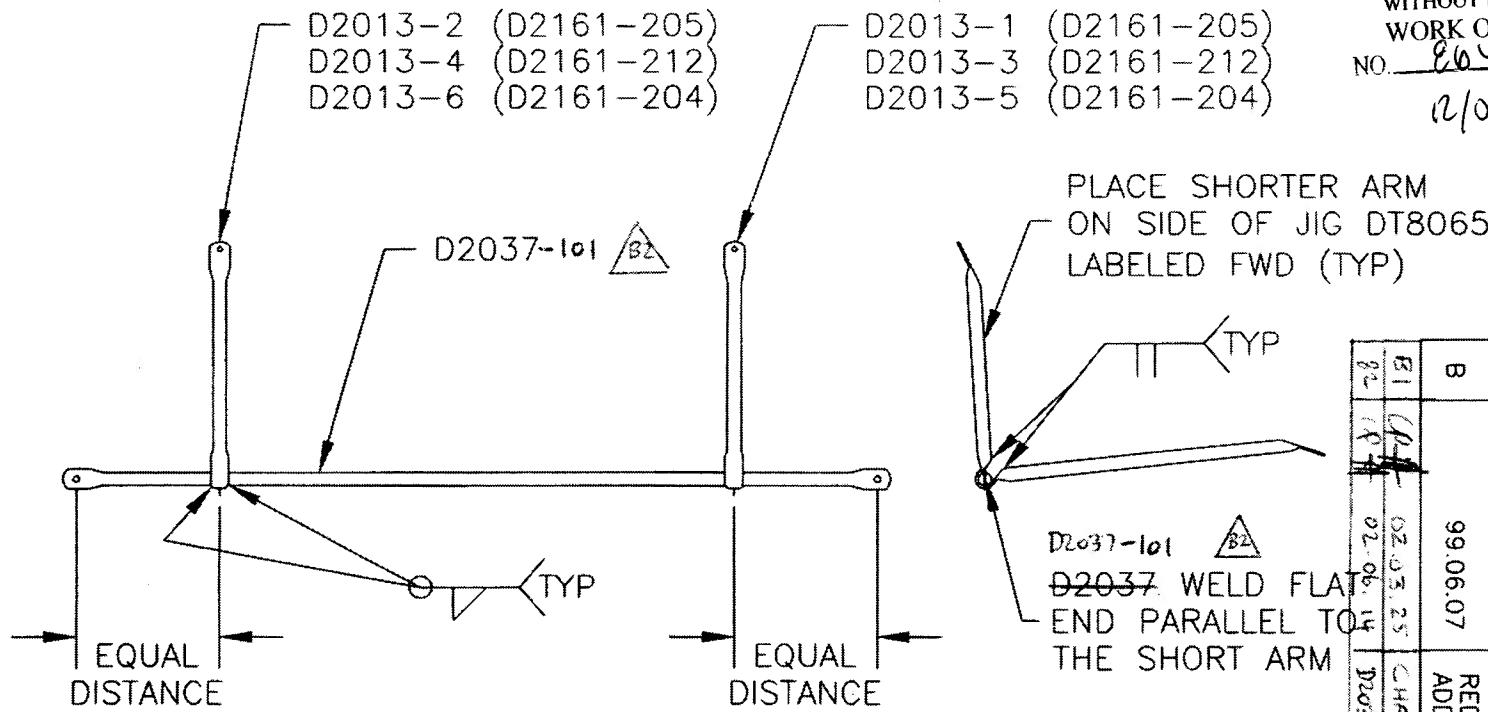
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86483 MLW
12/06/29

DART

3 COPIES
DATE

DESIGN JB	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED V	DRAWING NO. D2161
DATE 99.06.07	TITLE MIRROR BRACKET	REV. B SHEET 1 OF 1 SCALE N/A
A	93.04.29	NEW ISSUE
B1	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B2	02.06.14	D2037-101 W/ CHASSE FINISH



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: POWDER COAT ASSEMBLY BLACK
CRINKLE (4.3.5.3) PER DART QSI 005 4.3
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 B2

RELEASED
KE 4466-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 PARTS LIST

REFERENCE ONLY

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR